

Date: Monday, 1/14/2008 2:33:16 PM
User: Kim Johnston

Process Sheet

*Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36737
 Estimate Number : 10270
 P.O. Number :
 This Issue : 1/14/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 36500
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 04.03.22 New issue KJ/RF
 Est Rev:B 07-06-09 Added D3272-1 JLM

Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
 Part Number : D350591311
 Drawing Number : D3272 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 2/10/2008 Qty: 10 Um: Each

(9)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

5 0812106

2.0 D32721 STEP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: 336759

14 08.01.28 10

3.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 335804

14 08.01.28 10

4.0 D32191 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support 327592 = 7

336114 = 13

14 08.01.28 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 36737

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod B M105052
M105244

3-Grind End Plate flush

Sh 08.01.28 10
Sh 08.01.29 10
SAD 08.01.29 10

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08.01.29 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sh 08.01.29 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08.01.29 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Sh 08.01.29 10

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy 335622

Sh 08.01.30 10

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer 336410

Sh 08.01.30 10

Date: Monday, 11/14/2000 2:00:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 36737

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet M106309=105 M106654=55 08-01-30 10

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

08-01-30 10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-30 (X106H)

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 335204

08-01-30 10

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M105058

4-Grind End Plate flush

5-Install last rivet as per Dwg.

08-01-30 10

08-01-30 10

08-01-30 10

SAD 08:01:30 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 36737

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD8/01/31 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/31 (106H)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
touch up alodine

M-6/6 08/02/01

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-02-01 (9x)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

08/02/04 (9)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08/02/05 (9 LH)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

30273 x 1

35470 x 2

35800 x 32

36748 x 1

AS 08/02/05 (9x)
* last 2 of an old batch not in computer
New Batch

Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Number: 36737

Part Number: D350591311

Number:



Seq. #: Machine Or Operation: Description :

25.0 D2618 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing ~~35096~~ 35096 ~~AS~~ 8/2/05

26.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip ~~35900~~ 35900 ~~AS~~ 8/2/05

27.0 D32351 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug ~~33249~~ 33249 ~~AS~~ 8/2/05

28.0 D3278041 Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly ~~35081~~ 35081 ~~AS~~ 8/2/05

29.0 AN335A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt ~~M105408~~ M105408 ~~AS~~ 8/2/04

30.0 AN413A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A Bolt ~~M106815~~ M106815 ~~AS~~ 8/2/04

Date: Monday, 1/14/2008 2:33:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 36737

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M106513

AS 08/02/05

(x9)

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M106167

AS 08/02/05

(x9)

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M106780

AS 08/02/05

(x9)

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M106167

AS 08/02/05

(x9)

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M105558

AS 08/02/05

(x9)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 36737

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105938

AS 08/02/05

(X9)

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M105940

AS 08/02/05

(X9)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/02/05

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location:

Rev B

AS 08/02/06

(X9)

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/08

Job Completion



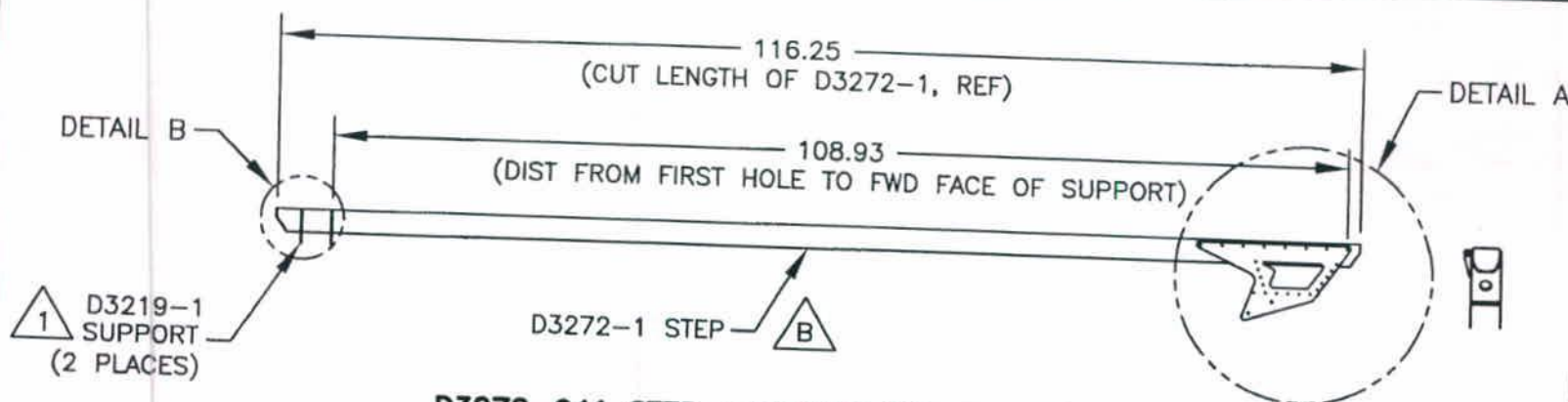
in 2008/2/07

(9)

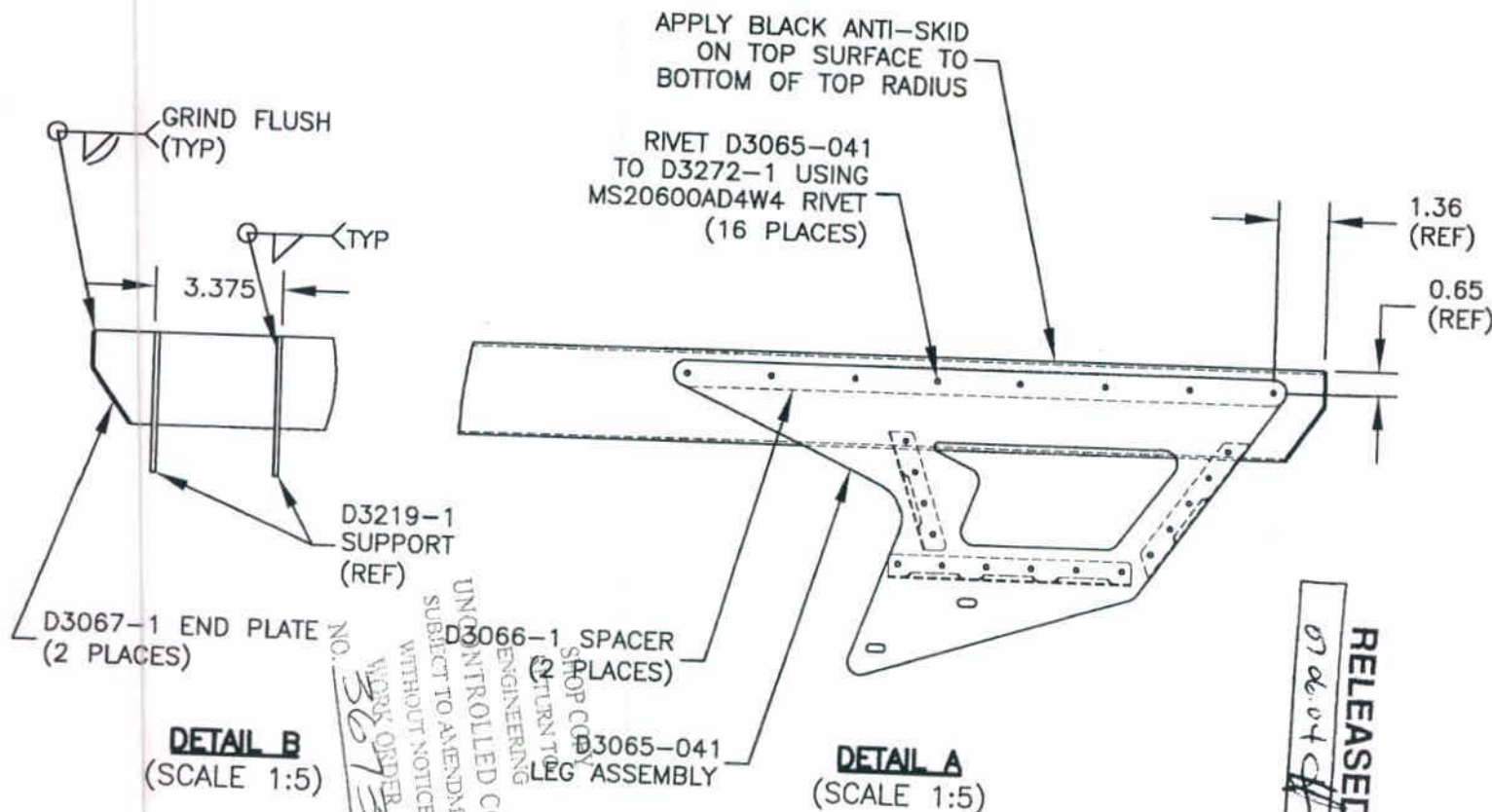
W

DART

DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 36737

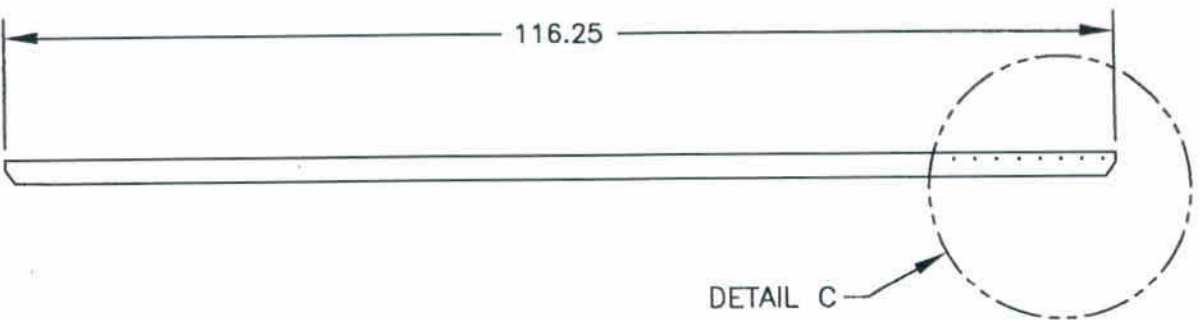
DART

DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

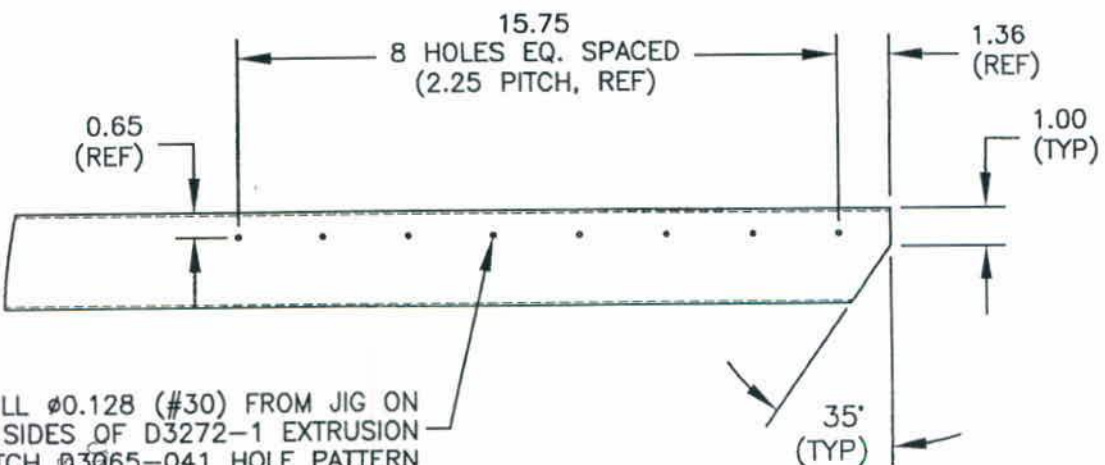
RELEASED

07.06.04



DETAIL C

△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH 03065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3673

Date: Monday, 1/14/2008 2:33:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
 Job Number : 36737
 Estimate Number : 10270
 P.O. Number :
 This Issue : 1/14/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350591311
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : D3272 REV B
 Previous Run : 36500 Drawing Revision : B
 Material :
 Due Date : 2/10/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 04.03.22 New issue KJ/RF
 Est Rev: B 07-06-09 Added D3272-1 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

08:01.31

2.0 D32721 STEP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: _____

3.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate _____

REFERENCE ONLY

4.0 D32191 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)



Pick:

Qty Part Number Description Batch

2 D3219-1 Support _____

User: Tuesday, 08/04/2008 8:53:19 AM
Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE KIT-DSI 9410
Job Number	: 38471		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 08/04/2008 S.O. No. :	Drawing Number	: ECN1164
Prsht Rev.	: NC	Project Number	:
First Issue	: 08/04/2008 Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 15/04/2008 Qty: 8 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK :
D350-591-311

Ch1 B36737 x7

D350-590-312

Ch1 B38121 x1

ADD NEW PAPERWORK AND KIT DSI9410
PER ECN1164

RETURN KITS TO STOCK

AS 08/04/09 x8

2.0	DSI9410011	STEP MODIFICATION KIT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
STEP MODIFICATION KIT

B 38472

AS 08/04/09 (8)

3.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/04/10 H

Job Completion



mf 08-04-14